

Work Order ID 81543

March-15-12 10:31:28 AM

81543

Page 1

Item ID: D3641-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cover
 Start Date: 15/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/15 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3641	Rev C

100	FLOW WATER JET	0.00							
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100
 Waterjet
 FLOW CNC Waterjet
SOS. 032
 Memo
 1-Cut as per Dwg D3641
 Dwg Rev: C
 Prog Rev: L
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
 QC
 Quality Control
 Memo

120	QC8- Inspect parts - second check	0.00							
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120
 QC
 Quality Control
 Memo

B2-4-12

(14)

B2-4-12

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3641-1								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

SB 12/04/16

8/2/16

(14) 7/6 12.4.17

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Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/03/2012 **Start Qty:** 12.00

12

Cust Item ID:**Required Date:** 29/03/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: S260 0.00

.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-15-12 10:31:32 AM

Page 1

Work Order ID: 81543

81543

Parent Item: D3641-1

D3641-1

Parent Item Name: Cover

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	223.8000	0.7987	10.08884	12,		

M5052H32S 032

5052-H32 .032 Sheet

B12-4-12

Location

Loc Qty

Loc Code

MAT022

223.8

112664

10.4

115638

12

116657

20.5

117798

20.9

121030

64

121040

96

121040

(14)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81543
Description: Cover		Part Number:	D3641-1
Inspection Dwg: D3641 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	.193	2		V BO2	
0.191	+/-0.010	.194	2		V	
0.37	+/-0.030	.373	2		V	
0.54	+/-0.030	.543	1		V	
0.69	+/-0.030	.691	2		V	
11.86	+/-0.030	11.86	1		T BO1	
12.22	+/-0.030	12.22	2		T	
23.37	+/-0.030	23.77	2		T	
23.54	+/-0.030	23.54	1		T	
23.69	+/-0.030	23.69	2		T	
24.06	+/-0.030	24.66	2		T	
0.50	+/-0.030	.504	2		V	
4.28	+/-0.030	4.279	2		V	
4.78	+/-0.030	4.786	2		V	
0.032	+/-0.010	.034	2		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 12-4-12	Date: 12/6/12	Date:

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	12.03.08	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

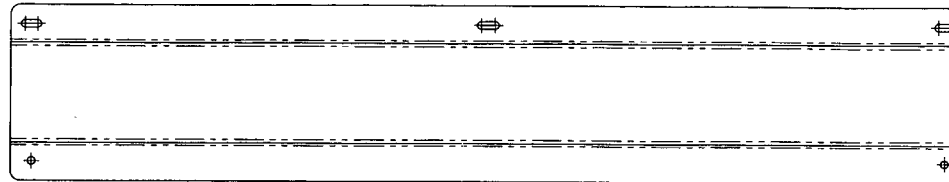
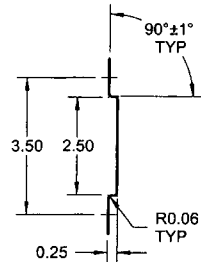
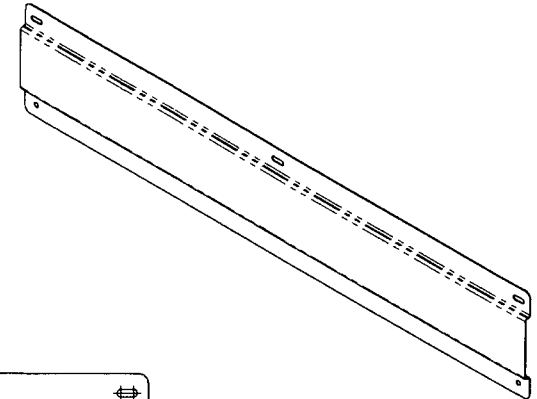
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81543 *MLJ*
12/03/15



D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)
(MAKE FROM D3641-1F FLAT PATTERN)

RELEASED
2009-11-18
WP

NOTES:

- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

C	REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F/-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076	RF	09.10.02
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3641	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER	NTS
DATE	09.10.02	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

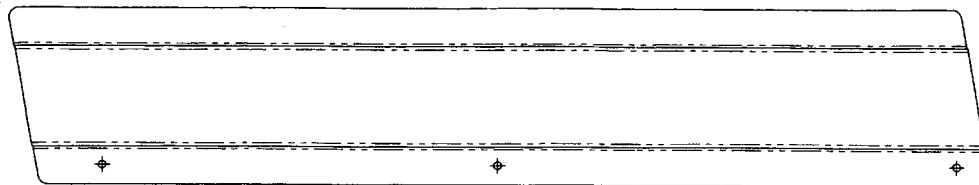
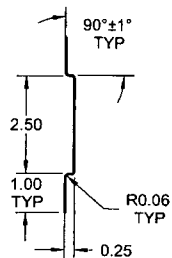
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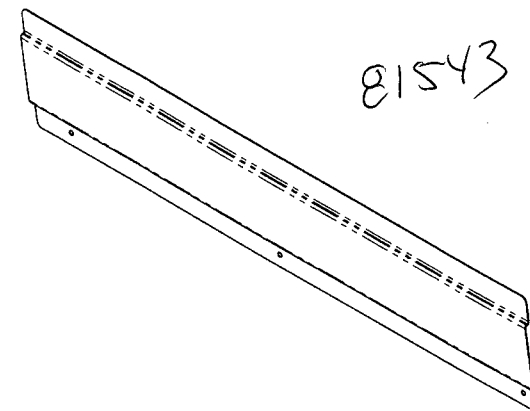
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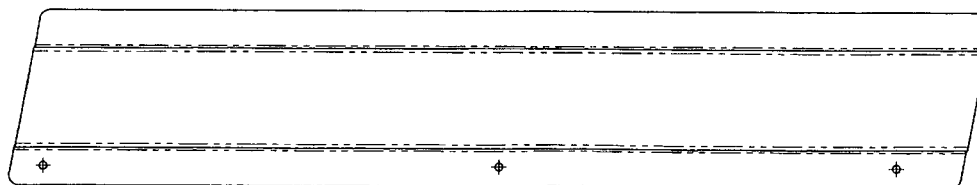
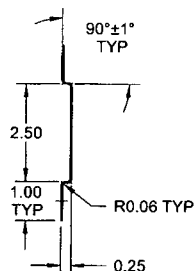
NOTE: Date & initial all entries



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5) $\triangle C$
(MAKE FROM D3641-3F FLAT PATTERN)



D3641-3 COVER (SHOWN)
D3641-4 COVER (OPPOSITE)



D3641-4 COVER
(REPLACES GENEVA P/N G10606-4) $\triangle C$
(MAKE FROM D3641-3F FLAT PATTERN)

RELEASED
2009-11-10
AMP

NOTES:

- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3641	REV. C
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE COVER	SCALE NTS
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DATE	09.10.02		

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

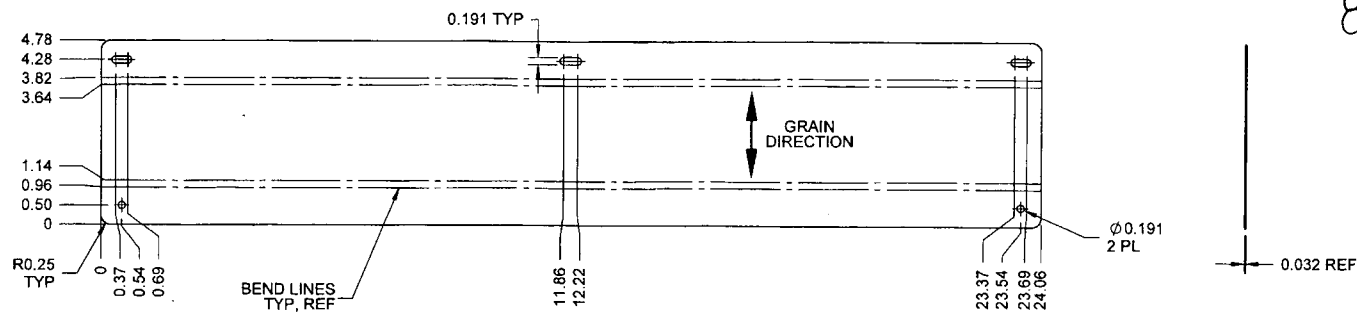
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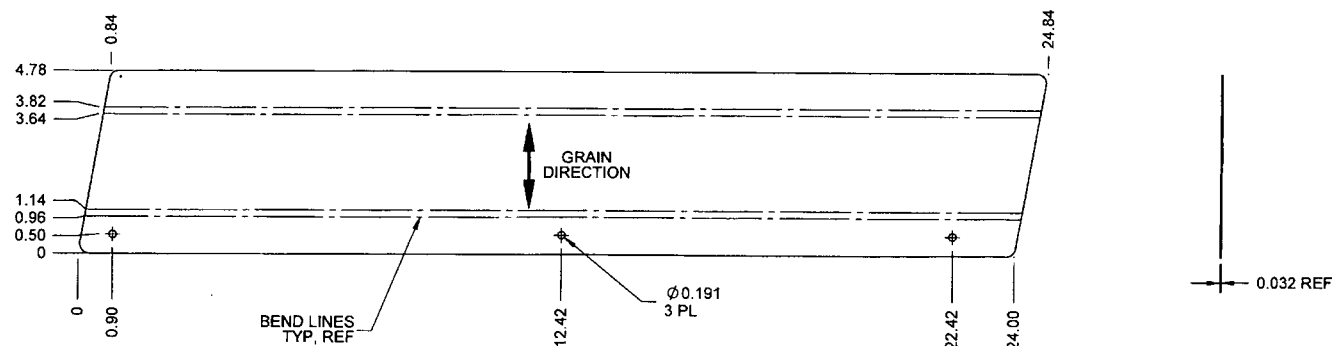
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NOTE: Date & initial all entries

81543



D3641-1F FLAT PATTERN



D3641-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1F/-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 3 OF 3
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